



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

648.4702

Job Sheet 180413



005215

Part No: 648.4702

Job Qty: 1 ea

Part Name: C3 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: O&OPM-C3 REV.4 IPP REV:A 17.12.11 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Stores/Pkg-1		7.18
110	Small Fab	1 pcs	8/7/18	8/7/18	0.00	1.00	Small Fab-9		7.18 D4S
120	QC	1 pcs	8/7/18	8/7/18	0.00	0.00	QC4		D4S 38
130	Packaging	1 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-1		2.80 9-89
135	DC	1 pcs	8/7/18	8/7/18	0.00	0.00	DC		9-89 SEP 2 2018
140	QC21-FG	1 Ea	8/7/18	8/7/18	0.00	0.00	QC21		D4S 21 9-89

Part Op 110 - Pick kit

Descriptions: 130 - Identify and pack for shipping as per PPP 648.4702

135 - Photocopy bluefile & type labels per PPP 648.7402

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	5073061
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	5058763
600.1309-A	Label	1 Ea (1 ea)	90-Start up Operation	5064516
600.1313P	C3 Warning Label	1 Ea (1 ea)	90-Start up Operation	5029483
AN4-16A	Bolt	3 Ea (3 ea)	90-Start up Operation	5082909
C2-14-2	Label Rivets	2 Ea (2 ea)	90-Start up Operation	5040661
C2-3-1	Bearing DU	2 pcs (2 ea)	90-Start up Operation	5068886
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	90-Start up Operation	5056845
C2-3-3-1	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	5050472
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	90-Start up Operation	5058758
C2-3-8	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	5079664
C3-10-2	Lock Spring	1 Ea (1 ea)	90-Start up Operation	5078462
C3-12-1	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	5035073
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	90-Start up Operation	5026888
C3-13-1	Keeper Bushing	2 pcs (2 ea)	90-Start up Operation	5068888
C3-13-5	Spring, Keeper	1 pcs (1 ea)	90-Start up Operation	5089547
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	90-Start up Operation	5082380
C3-3-9	Actuator Spring	1 pcs (1 ea)	90-Start up Operation	5090963
C3-4-1-PO	Load Beam Bushing	2 Ea (2 ea)	90-Start up Operation	5075080
C3-7-1 GA179	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	5029283
C3-7-2 GA179	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	5079777
C3-8-4 GA179	Solenoid Cover Gasket	1 Ea (1 ea)	90-Start up Operation	5079782

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step : _____ Description Work Order: _____	AGAINST DEPARTMENT/PROCESS Part No. _____ Water Jet _____ Part: 046-4702 Job No: 180413 Serial No/Batch: S106248 Revision: 4 Inspector: _____ Exf Date: _____ Instructions: _____ Engineering ☐ Quality ☐ Other ☐ MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____						
Root Cause <table style="width: 100%;"> <tr> <td style="width: 33%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 33%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> </tr> </table>	Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	<table style="width: 100%;"> <tr> <td style="width: 33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width: 33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table> OTHER : _____	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐					
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NAS1149F0463P	Washer	8 Ea (8 ea)	90-Start up Operation	FM144832 25 507878
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	90-Start up Operation	5092510
AN4-17A	Bolt	1 Ea (1 ea)	90-Start up Operation	5070182 5089287
MS21083N3	Nut <i>Alain</i>	2 Ea (2 ea)	90-Start up Operation	5036469
NAS1149F0332P	Washer	2 Ea (2 ea)	90-Start up Operation	5071415 5099746
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	90-Start up Operation	5038767
NAS1149F0363P	Washer	1 Ea (1 ea)	90-Start up Operation	5075330
AN6-15A	Bolt	1 Ea (1 ea)	90-Start up Operation	5076004
MS21083N6	Nut <i>Alain</i>	1 Ea (1 ea)	90-Start up Operation	5036359
NAS1149F0632P	Washer	2 Ea (2 ea)	90-Start up Operation	5048297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	157	0
	188-FSCS-832-5/8	4	128	0
	600.1309-A	1	0	0
	600.1313	1	0	0
	AN4-16A	3	361	0
	AN4-17A	1	308	0
	AN6-15A	1	48	0
	C2-14-2	2	206	0
	C2-3-1	2	44	0
	C2-3-2-1	2	60	0
	C2-3-3-1	1	15	0
	C2-3-5	2	67	0
	C2-3-8	2	66	0
	C3-10-2	1	24	0
	C3-12-1	2	9	0
	C3-12-6	2	63	0
	C3-13-1	2	50	0
	C3-13-5	1	0	0
	C3-3-4-1	4	184	0
	C3-3-9	1	0	0
	C3-4-1	2	1	0
	C3-7-1	1	0	0
	C3-7-2	2	10	0
	C3-8-4	1	15	0
	MS21044N4	4	74	0
	MS21083N3	2	297	0
	MS21083N6	1	164	0
	MS35266-63	1	71	0
	NAS1149F0332P	2	1,489	0
	NAS1149F0363P	1	643	0
	NAS1149F0463P	8	747	0
	NAS1149F0632P	2	585	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								